

Work Order ID 52293

Tuesday, September 22, 2009 1:57:13 PM

Page 1

Item ID: D3898-1

Accept

Revision ID: A

Item Name: Floor Protector (206L)

Start Date: 9/23/2009 Start Qty: 5.00

Required Date: 10/9/2009 Req'd Qty: 5.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3898

Rev A

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA0xxusing tool DT9501
Dwg Rev: A
Folio Rev: A

09/29/09

BB

x5

09/10/05

BB

x5



Work Order ID 52293




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Item ID: D3898-1 Accept  Setup Start 
Revision ID: A  Cust Item ID: Stop 
Item Name: Floor Protector (206L)  Customer:
Start Date: 9/23/2009 Start Qty: 5.00
Required Date: 10/9/2009 Req'd Qty: 5.00
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|-----------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|-----------------------|
| 120  QC Quality Control | QC2- Inspect parts off machine FAI/FAIB Memo Visually inspect part for proper formation and texture | 0.00 0.00 | | | | | | | RB 09/10/09 X5 |
| 130  QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | | | | | | 09/09/29 X5 14h |
| 140  HandThermo Hand Finishing Thermoforming | Memo 1-Trim to finished dimensions as per Dwg | 0.00 0.00 | | | | | | | 09/09/30 X5 14h |

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Item ID: D3898-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Floor Protector (206L)

Start Date: 9/23/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

09/09/30 (X5)
Sh.

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 Serials

(25) 4

170

Identify as per dwg & Stock Location: PDP

0.00



Packaging

Memo

0.00

Packaging

50917

- (09/10/16) (5)

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Item ID: D3898-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Floor Protector (206L)

Start Date: 9/23/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/19 JJ

MF
09-10-16

Picklist Print

September 29, 2009 1:21:10 PM

Page 1

Work Order ID: 52293



Parent Item: D3898-1RevA



Parent Item Name: Floor Protector (206L)

Start Date: 09/23/2009

Required Date: 10/09/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| MLEXS.118-90318-08 | | Purchased | No | | | | sf | 445.6200 | 10.6000 | | | |
| | | | | | | | | | | | | |

Lexan Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

111588

445.62

445.62

5

09/29/09

BB

| | | | |
|--------------------------------------------|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 52293 |
| Description: Floor Protector | | Part Number: | D3898-1 |
| Inspection Dwg: D3898 Rev: A | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

| Description | Accept | Reject | Method of Inspection | Comments |
|-----------------------------------------------------------------|--------|--------|----------------------|----------|
| Inside Radii less than " | | | | |
| Shape Definition | | | | |
| Texture Retention | | | | |
| Material imperfections such as bumps, cracks, voids, scratching | | | | |
| | | | | |
| | | | | |
| | | | | |

Measured by: _____

Date: _____

TRIMMING SECTION

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 0.50 | Min | 0.542 | ✓ | | | |
| 1.00 | Min | 1.033 | ✓ | | | |
| 5.6 | +0.2/-0.0 | 5.6 | ✓ | | | |
| 0.080 | Min | 0.084 | ✓ | | | |
| 0.050 | Min | 0.087 | ✓ | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

Measured by: *Sh*

Date: 09/09/30

Audited by: *BB*

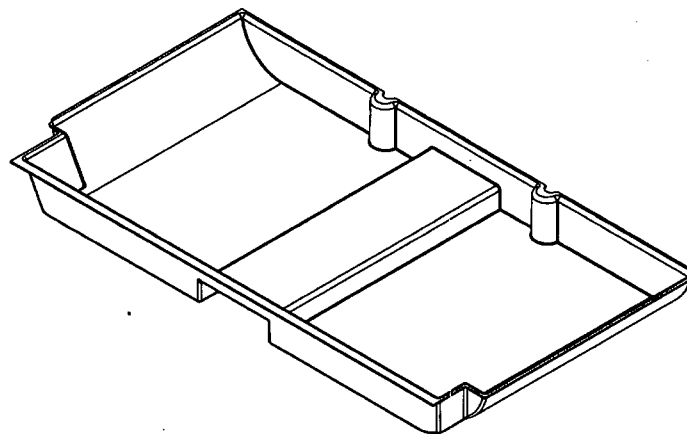
Date: 09/09/30

Prototype Approval: N/A

Date: N/A

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|--------------------|
| A | 09.09.15 | New Issue | KJ | <i>[Signature]</i> |

SHOP COPY
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 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 52223



D3898-1 FLOOR PROTECTOR (206L)

RELEASED
 09/06/08 JHL

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3898-1" USING VIBRATING STYLUS
- 7) WEIGHT: 5.0 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9501 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

| A NEW ISSUE | | PH | 09.02.27 |
|-------------|-------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| REV. | DESCRIPTION | | BY DATE |
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | PH | | |
| CHECKED | PH | DRAWING NO. | REV. A |
| MFG. APPR. | PH | D3898 | SHEET 1 OF 2 |
| APPROVED | PH | TITLE | SCALE |
| DE APPR. | PH | FLOOR PROTECTOR (206L) | NTS |
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52293

